



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2144

Job Sheet 175744



Part No: D2144

Job Qty: 10 ea

Part Name: Hinge Doubler



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/10/18

Job Tracking No:

Due Date: 4/24/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV D IPP: D 04.05.06 Reformat KJ/RF IPP Rev:E Now on Waterjet 06-10-15 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	4/23/18	4/23/18	0.00	0.00	Start Up Waterjet		SC 18/04/18
100	Waterjet	10 pcs	4/23/18	4/23/18	0.00	0.56	Waterjet1		SC 18/04/18
110	QC	10 pcs	4/23/18	4/23/18	0.00	0.00	QC2 Waterjet-1		SC 18/04/18
120	QC	10 pcs	4/23/18	4/23/18	0.00	0.00	QC8-1		38
130	Small Fab	10 pcs	4/23/18	4/23/18	0.00	0.38	Small Fab-1		3-89 N/A
140	Brake NC	10 pcs	4/23/18	4/23/18	0.01	0.68	Brake NC 2		8-89 DAS
150	QC	10 pcs	4/23/18	4/23/18	0.00	0.00	QC5		AUG 17 2018 8-89
160	Large Fab	10 pcs	4/23/18	4/23/18	0.00	1.80	Large Fab 1		DIC 18/08/21 8-89
170	QC	10 pcs	4/23/18	4/23/18	0.00	0.00	QC9		8-89
180	QC	10 pcs	4/23/18	4/23/18	0.00	0.00	QC5		8-89
190	Powdercoat	10 pcs	4/24/18	4/24/18	0.00	0.18	Powdercoat1		SEP 07 2018 8-89
200	QC	10 pcs	4/24/18	4/24/18	0.00	0.00	QC3		SEP 07 2018 8-89
210	Packaging	10 pcs	4/24/18	4/24/18	0.00	0.00	Packaging3-1		SEP 07 2018 8-89
220	QC21-SA	10 Ea	4/24/18	4/24/18	0.00	0.00	QC21		21 SEP 11 2018 8-89

Part Op 100 - 1-Cut as per Dwg D2144

Descriptions: 130 - Deburr if necessary

140 - Form as per Dwg D2144 Rev: _____

160 - 1- Weld corner as per Dwg D2144 & QSI 004 2- Grind flush

190 - START TIME: 2:30

FINISH TIME: 3:00

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	.9450 sf (.0945 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S16GA	1	236	0

Part Specifications

Specifications could not be found.



Container No: S061072



Part: D2144

Job No: 175744

Serial No/Batch: S061072

Revision:

Inspector:

Dart Aerospace Ltd.
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Date: 04/15/18

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DART AEROSPACE LTD		Work Order: 175744
Description: Hinge Bracket		Part Number: D2144
Inspection Dwg: D2144	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.381	+/-0.010	3,384	1		VSC-01	
3.022	+/-0.010	3,026	1			
2.468	+/-0.010	2,470	1			
1.913	+/-0.010	1,915	1			
1.555	+/-0.010	1,557	1			
4.126	+/-0.010	4,124	1			
3.465	+/-0.010	3,468	1			
0.340	+/-0.010	0,344	1			
0.625	+/-0.010	0,628	1			
1.000	+/-0.010	1,001	1			
1.083	+/-0.010	1,085	1			
1.660	+/-0.010	1,664	1			
2.312	+/-0.010	2,314	1			
2.844	+/-0.010	2,845	1			
3.294	+/-0.010	3,295	1			
Ø0.257	+0.006/-0.001	Ø0,258	1			
Ø0.171	+0.005/-0.001	Ø0,171	1			
Ø0.320	+0.006/-0.001	Ø0,320	1			
0.354	+/-0.010	0,355	1			
0.063	+/-0.010	0,058	1			

Measured by: JC	Audited by: [Signature]	Prototype Approval:	N/A
Date: 18/04/15	Date: APR 16 2018	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.31	New Issue	KJ/JLM [Signature]	[Signature]